

Date: Friday, 28/03/2008 12:42:18 PM  
User: Jean-Luc Menard

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BEARING CAP
Job Number	38233		
Estimate Number	12412		
P.O. Number	:	Part Number	: D312125
This Issue	28/03/2008	Drawing Number	: D3121 REV E
Prsht Rev.	NC	Project Number	: N/A
First Issue	11	Drawing Revision	: E
Previous Run	36151	Material	:
Written By	<u>JLM 08.03.28</u>	Due Date	: 04/04/2008
Checked & Approved By		Qty:	30
Comment	Est Rev/A New Issue 06-05-10 JLM Est Rev/B ECN 1060 07-11-12 DD verified by:EC	Um:	Each
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINR12500	DELRIN ROUND BAR 1.25"	
			
Comment: Qty.: 0.0546 f(s)/Unit Total : 1.6380 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) Identify as D3121-25 Batch: <u>M104328</u> <span style="float: right;"><u>Ex. 03. 29</u></span>			
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
			
Comment: HARDINGE CNC LATHE SMALL  1-Turn D3121-25 Cap as per Folio FA387  2-Deburr <span style="float: right;"><u>Ex. 03. 29</u></span> <span style="float: right;">30</span>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <span style="float: right;"><u>Ex. 03. 29</u></span> <span style="float: right;">30</span>			
4.0	QC8	SECOND CHECK	
			
Comment: SECOND CHECK <span style="float: right;"><u>Ex. 03. 29</u></span> <span style="float: right;">30</span>			
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
			
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>66</u> <span style="float: right;"><u>Ex. 03. 29</u></span> <span style="float: right;">30</span>			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING CAP

Job Number: 38233

Part Number: D312125

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08 04.01  
JL

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



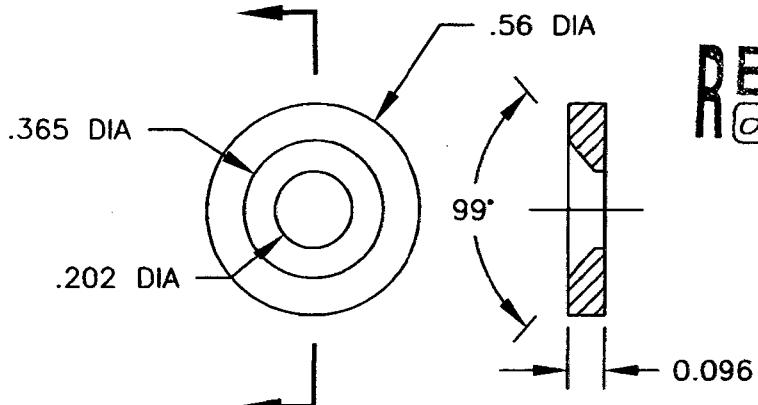
mr

08-03-31

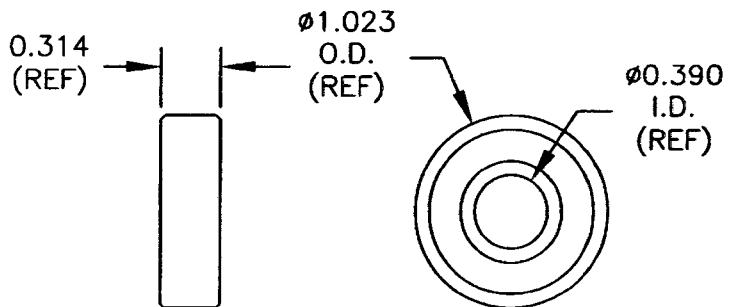
W

**DART**

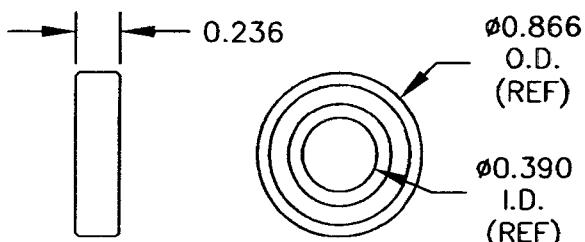
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
		03121	REV. E
DATE	TITLE	SHEET 10 OF 10	SCALE
07.11.07	BRACKET ASSEMBLY	1:1	

**D3121-17 WASHER (SCALE 2:1)**

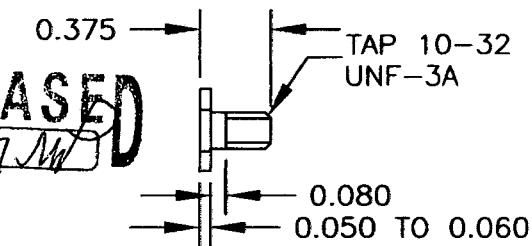
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

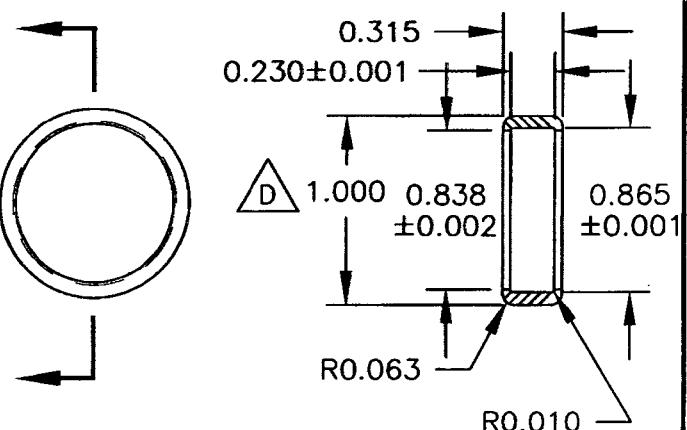
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM  
FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

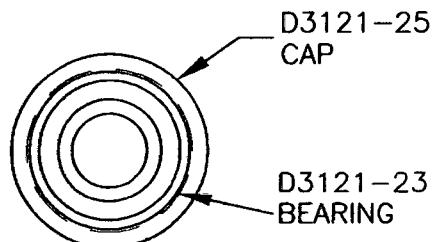
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z  
OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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DART AEROSPACE LTD	Work Order:	38233
Description: Cap	Part Number:	D3121-25
Inspection Dwg: D3121 Rev: E		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	<u>SG</u>	Audited by:	<u>ml</u>	Prototype Approval:	N/A
Date:	08.03.29	Date:	08/03/29	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	✓